

Work Order ID 60717

Wednesday, July 21, 2010 7:38:07 AM

Page 1

Item ID: D4021-5

Accept

Setup ,Start

Revision ID:

Stop

Item Name: Blanking Plate

Start Date: 7/21/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: *mr*Date: *10-7-21*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4021

B

100

0.00



Waterjet

FLOW CNC Waterjet

304 . 063

Memo

Cut as per dwg D4021

Prog Rev: *B*Dwg Rev: *B*

Deburr as required

*SD 10/07/21**FB 10-7-21**(15)**FB 10-7-21*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Powdercoat

Memo

0.00

Powder Coating

135

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control



S 10/07/21

(415)

M 11/24/11 START. 130
O 02/21/12 Q 02/21/12
FINISH: 2:00

15 BRP-72L

JH 10/07/21

15 9

W/O:		WORK ORDER CHANGES						
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Page 3

Item ID: D4021-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Blanking Plate

Start Date: 7/21/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

140

Identify as per dwg & Stock Location: ST 111

0.00



Packaging

Memo

0.00

Packaging

MF 10-7-21

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/22 HJMF
10-7-21

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Picklist Print

Wednesday, July 21, 2010 7:38:07 AM

Page 1

Work Order ID: 60717



Parent Item: D4021-5

Parent Item Name: Blanking Plate

Start Date: 7/21/2010

Required Date: 7/22/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB
DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	45.5267	0.0622	0.654737			



304/316 Sheet .063



RB 10-7-21

Location

Loc Qty

Loc Code

MAT

45.52669474

111323

0

114799

45.5266947

114799

15

W/O:		WORK ORDER CHANGES					
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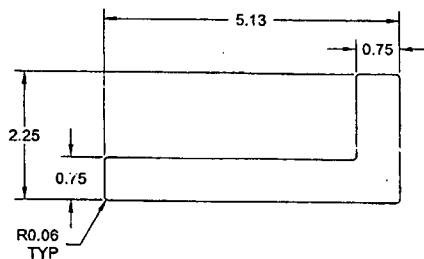
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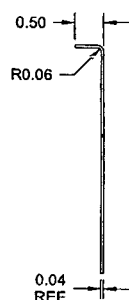
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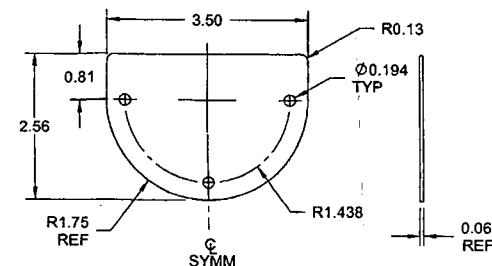
NOTE: Date & initial all entries



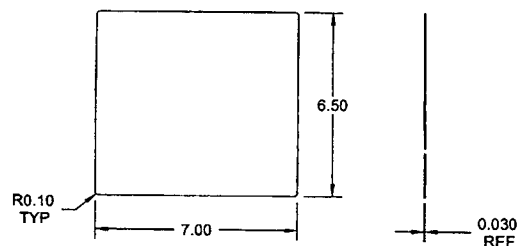
D4021-1 HANDLE PLATE



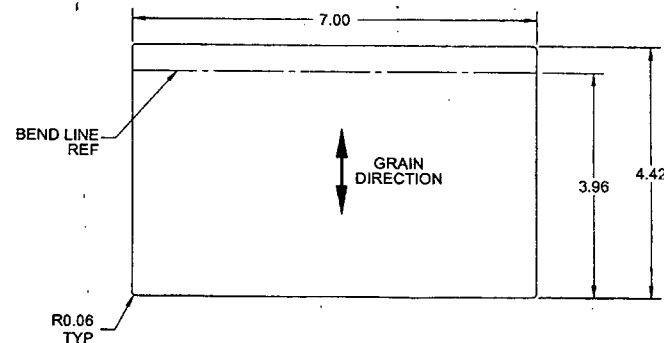
D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-3F DATA PLATE
FLAT PATTERN

NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

2) FINISH: -1/-3/-11: NONE

- 5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs -3: 0.35 lbs -5: 0.14 lbs -11: 0.39 lbs

RELEASED
R 2010-04-14
NIP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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